

Date: Tuesday, 03/02/2009 2:35:46 PM  
 User: Julie Dawson

## Process Sheet

Customer : CU-DAR001 Dart Helicopters Services	Drawing Name : TURNING DETAIL FOR D2940-1
Job Number : 45471	
Estimate Number : 13237	
P.O. Number :	Part Number : DSK081
This Issue : 03/02/2009 S.O. No. :	Drawing Number : DSK081 REV.B
Prsht Rev. : NC	Project Number : N/A
First Issue : / / Type : MACHINED PARTS	Drawing Revision : B
Previous Run : 42613	Material :
Written By :	Due Date : 13/02/2009 Qty: 10 Um: Each
Checked & Approved By : <u>JUD 09.02.03</u>	
Comment : est rev A. 08.03.13 new issue EC	

## Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
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1.0	D6104007	Round Billet, 17-4
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Comment: Qty.: 1.0000 Each(s)/Unit Total : 10.0000 Each(s)

Billet

BATCH: B45659

2P 09/03/17

2.0	MORI SEIKI	MORI SEIKI CNC LATHE LARGE
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Comment: MORI SEIKI CNC LATHE LARGE

Turn blank as per Folio FA079

2P 09/03/17

3.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE
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Comment: INSPECT PARTS AS THEY COME OFF MACHINE

2P 09/03/17 (10)

4.0	QC8	SECOND CHECK
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Comment: SECOND CHECK

2P 09/03/23 (10)

5.0	PACKAGING 1	PACKAGING RESOURCE #1
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Comment: PACKAGING RESOURCE #1

Identify and Stock in Kanban

Location: CNC

2P 09/03/18 (10)

6.0	QC21	FINAL INSPECTION/W/O RELEASE
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Comment: FINAL INSPECTION/W/O RELEASE

09/03/24 2P

Job Completion



2P 09-03-23

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

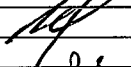

**NOTE:** Date & initial all entries



DART AEROSPACE LTD		Work Order: H5471
Description: Turning Detail for D2940-1		Part Number: DSK081
Inspection Dwg: DSK081	Rev: B	Page 1 of 1

### FIRST ARTICLE INSPECTION DIMENSION SHEET

☒ First Article ☐ Prototype

				Record Actual Dimensions				
Dim	Min	Max	Go/No Go Gauge	1	2	3	4	5
Lathe Section								
A	3.211	3.216		3.216	3.216	3.216	3.216	3.216
B	4.946	4.966		4.958	4.958	4.958	4.958	4.958
C	0.718	0.738		.728	.728	.728	.728	.728
D	0.090	0.110		.100	.100	.100	.100	.100
E	3.564	3.584		3.574	3.574	3.574	3.574	3.574
F	0.022	0.042		.032	.032	.032	.032	.032
G	3.444	3.464		3.454	3.454	3.454	3.454	3.454
H	0.112	0.132		.122	.122	.122	.122	.122
I	2.170	2.190		2.180	2.180	2.180	2.180	2.180
J	4.451	4.471		4.461	4.461	4.461	4.461	4.461
K	0.413	0.433		.423	.423	.423	.423	.423
L	0.913	0.933		.923	.923	.923	.923	.923
M								
N								
O								
P								

Measured by: 	Date: 09/03/18
Audited by: 	Date: 09/03/23
Prototype Approval:	Date:

Rev	Date	Change	Revised by	Approved
A	08.04.22	New Issue	KJ/JLM 	

**Dart Aerospace Ltd**

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

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Description: Turning Detail for D2940-1		Part Number: DSK081
Inspection Dwg: DSK081	Rev: B	Page 1 of 1

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M								
N								
O								
P								

Measured by: *[Signature]* Date: 09/03/18

Audited by: *[Signature]* Date: 09/03/18

Prototype Approval: \_\_\_\_\_ Date: \_\_\_\_\_

Rev	Date	Change	Revised by	Approved
A	08.04.22	New Issue	KJ/JLM	<i>[Signature]</i>

# Dart Aerospace Ltd

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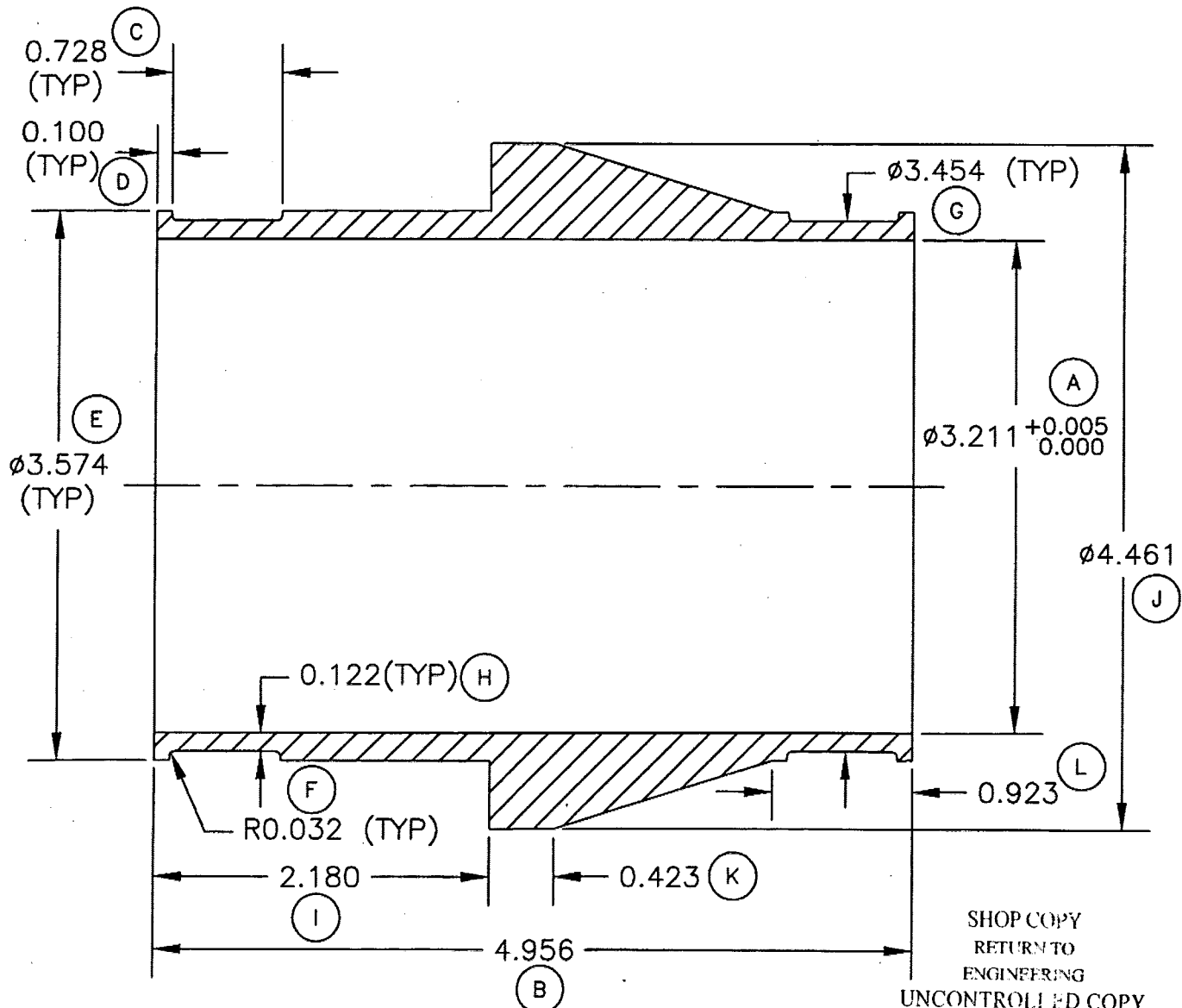
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**NOTE:** Date & initial all entries

**DART**

DESIGN <i>[Signature]</i>	DRAWN BY <i>[Signature]</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>[Signature]</i>	APPROVED <i>[Signature]</i>	DRAWING NO. DSK 081	REV. B SHEET 1 OF 1
DATE 03.06.24		TITLE TURNING DETAIL FOR D2940-1	SCALE 1:1
A	03.03.07	NEW ISSUE	
B	03.06.24	ADDED 4.956 DIMENSION	

RELEASED  
03-07-01

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